

Work Order ID 63699

November 10, 2010 10:46:54 AM

ASAP



Page 1

Item ID: D212-725-1-057F

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 11/10/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *u*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

G

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *G*

Prog Rev: *G*

2-Deburr if necessary

B10-11-10

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-11-10

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

Solal

(2)

QC

Memo

0.00

Quality Control

See Attached email about missing hrs.

121

Chemical Conversion Coat per QSI005 4.1

0.00

2.11 10/11/11

2 0

HandFinish

Memo

0.00

Hand Finishing

122

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

10/11/11 (2)

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Item ID: D212-725-1-057F

Accept

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Start Date: 11/10/10 Start Qty: 2.00

Required Date: 11/15/10 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 354

0.00



Packaging

Memo

0.00

Packaging

FLAT PATTERN ONLY

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CC 10/11/11 (2)

CC 10/11/11 *AD*

PL 10-11-11
(2)

Picklist Print

November 10, 2010 10:46:53 AM

Work Order ID: 63699

Parent Item: D212-725-1-057F

Parent Item Name: Bracket



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased		No		100	sf	98.4847	0.257	0.541053			



2024-T3 .050 sheet



R 10-11-10

Location

Loc Qty

Loc Code

MAT22

98.4847

111381

11.89

113189

0.3947

114968

86.2

114968

(2)

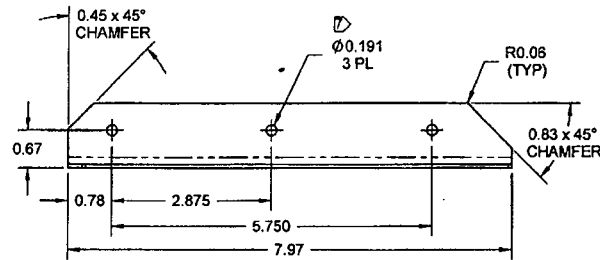
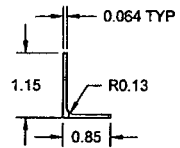
D212 - 725-1-057 F

X	First Article	X	Prototype
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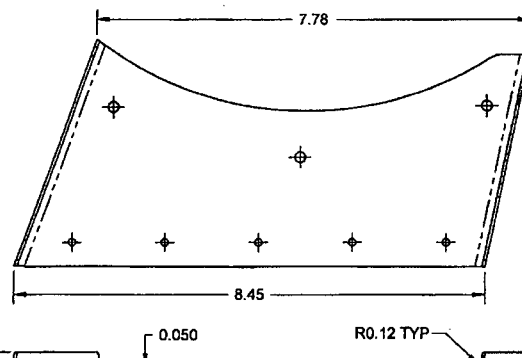
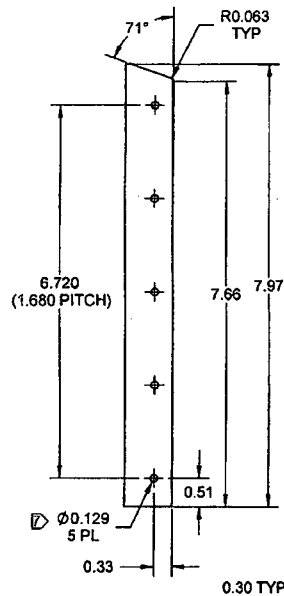
Measured by: HB	Audited by: S	Prototype Approval:
Date: 10-11-16	Date: 12/6/11	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revD

8 7 6 5 4 3 2 1



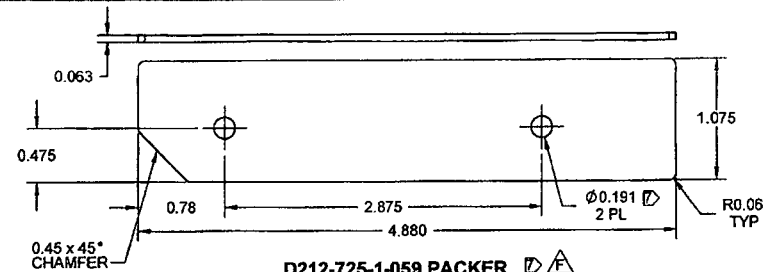
D212-725-1-055 ANGLE
MATERIAL: 2024-T3511 (QQ-A-200/3F) ANGLE EXTRUSION
(REF. DART SPEC. M2024T3-A)



D212-725-1-057 SUPPORT BRACKET
(MAKE FROM D212-725-1-057F FLAT PATTERN)
MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4
(REF. DART SPEC. M2024T3S.050)

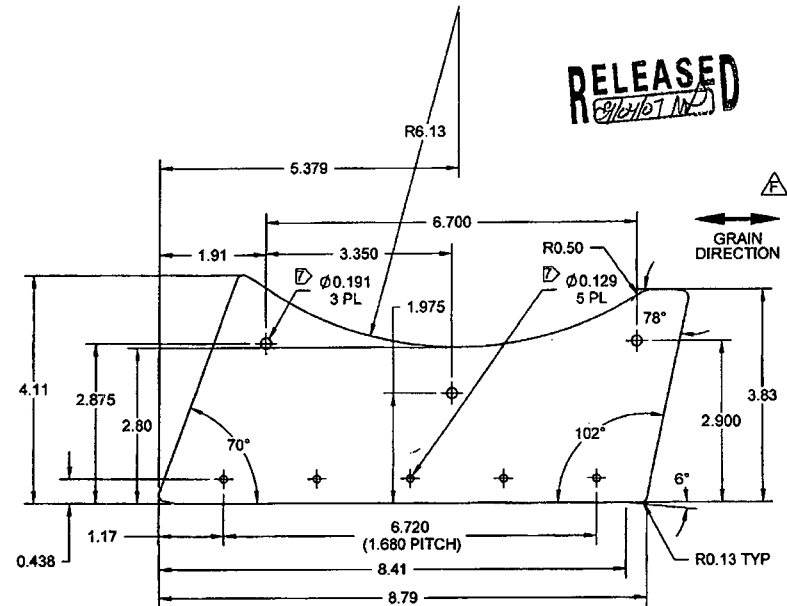
GENERAL NOTES:

- 1) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT IN ACCORDANCE WITH AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: N/A
- 7) DIMENSIONS BETWEEN HOLES ARE PROVIDED FOR REFERENCE ONLY, TRANSFER Ø0.129, Ø0.191 HOLES FROM AIRCRAFT



D212-725-1-059 PACKER
MATERIAL: 2024-T3 SHEET 0.063 THICK PER QQ-A-250/4
(REF. DART SPEC. M2024T3S.063)

RELEASED
9/16/07 M2



D212-725-1-057F FLAT PATTERN

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D212-725-1	SHEET 24 OF 84
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.02.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR AND PURPOSES OR CONSIDERED CONFIDENTIAL TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

also 63609

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

L Lacelle

From: Robert Fuentes [rfuentes@dartaero.com]

Sent: October 27, 2010 1:03 PM

To: 'L Lacelle'

Cc: 'H. Siemeris'; 'David Shepherd'

Subject: RE:

That be ok Linda, send that part as is, If they have problem I correct that when we release D-4 digits number.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]

Sent: Wednesday, October 27, 2010 9:47 AM

To: 'Robert Fuentes'

Cc: 'H. Siemens'; 'David Shepherd'

Subject: FW:

Roberto,

I have had these cut already to the dxf's you supplied, I can charge Eagle for the scrap parts, or you take them as is...what is your preference?

Please next time let someone know that the dwg or dxf is changed, we NEVER receive an ECN for the change in these parts, so no one knows about it!

LL

From: David Duval [mailto:dduval@dartaero.com]

Sent: October 27, 2010 11:43 AM

To: Linda Lacelle

Subject:

d212-725-1-123 do we cut it or what

[11:31:31 AM] David Duval: the rad is at 4.00"

[11:34:53 AM] Roberto Fuentes: the new radius is 3.75" from same center as old

[11:36:13 AM] David Duval: send me the new dxf with the new dwg

[11:41:32 AM] Roberto Fuentes: ok, I will send to replace old file that you have.

[11:42:22 AM] David Duval: plus the dxf you sent me is missing the 2 bottom hole .25"

David Duval

Production Engineering Coordinator



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Canada K6A 1K7

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dduval@dartaero.com



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10/27/10